

Wednesday, 5/28/2008 8:37:45 AM  
David Duval

## Process Sheet

012

Customer : CC-DAR01 Dart Aerospace Ltd. Drawing Name : REAR RAIL  
 Job Number : 39532  
 Estimate Number : 13348  
 P.O. Number :  
 This Issue : 5/28/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 11 Type : R&D MACHINED PARTS  
 Previous Run :  
 Written By : AD 08/05/28  
 Checked & Approved By :  
 Comment : Est Rev:A 08-05-27 new issue DD verified by:EC

Part Number : D37713  
 Drawing Number : D3771 PROTO  
 Project Number : IA0004  
 Drawing Revision : PROTO 08.06.27  
 Material :  
 Due Date : 6/4/2008 Qty: 1 Um: Each

Accuracy A  
 D3776-3 08.06.05

Additional Product

PROTOTYPE

Job Number:



FOR ENGINEERING USE ONLY

Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6T1000W188	6061T6 TUBE 1.00 X .188W
	Comment: Qty.: 2.9313 f(s)/Unit Total : 2.9313 f(s) 6061T6 TUBE 1.00 X .188W batch: <u>M104779</u> FF 08-05-28 ①	
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1 1- cut tube as per dwg D3771 FF 08-05-28 ①	
3.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP 08.05.28 ①	
4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
	Comment: 1- drill holes as per dwg D3771 2-Deburr holes and ends as per dwg D3771 08 05 28 1	
5.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP ENGINEERING APPROVAL PH 08.05.28	

Date: Wednesday, 5/28/2008 8:37:45 AM  
User: David Duval

## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: REAR RAIL

Job Number: 39532

Part Number: D37713

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*JD 08.05.28*

*1*

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*pt 06.05.27*

8.0

PACKAGING 1

PACKAGING RESOURCE #1



FOR ENGINEERING USE ONLY



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*PD 06.05.29*

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*1108.05.29 Prototype*

Job Completion



*Charge to W/O  
# 00196*

*U 08-06-11*

# PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D412-769

Job #: 00196

Date: 08.05.27

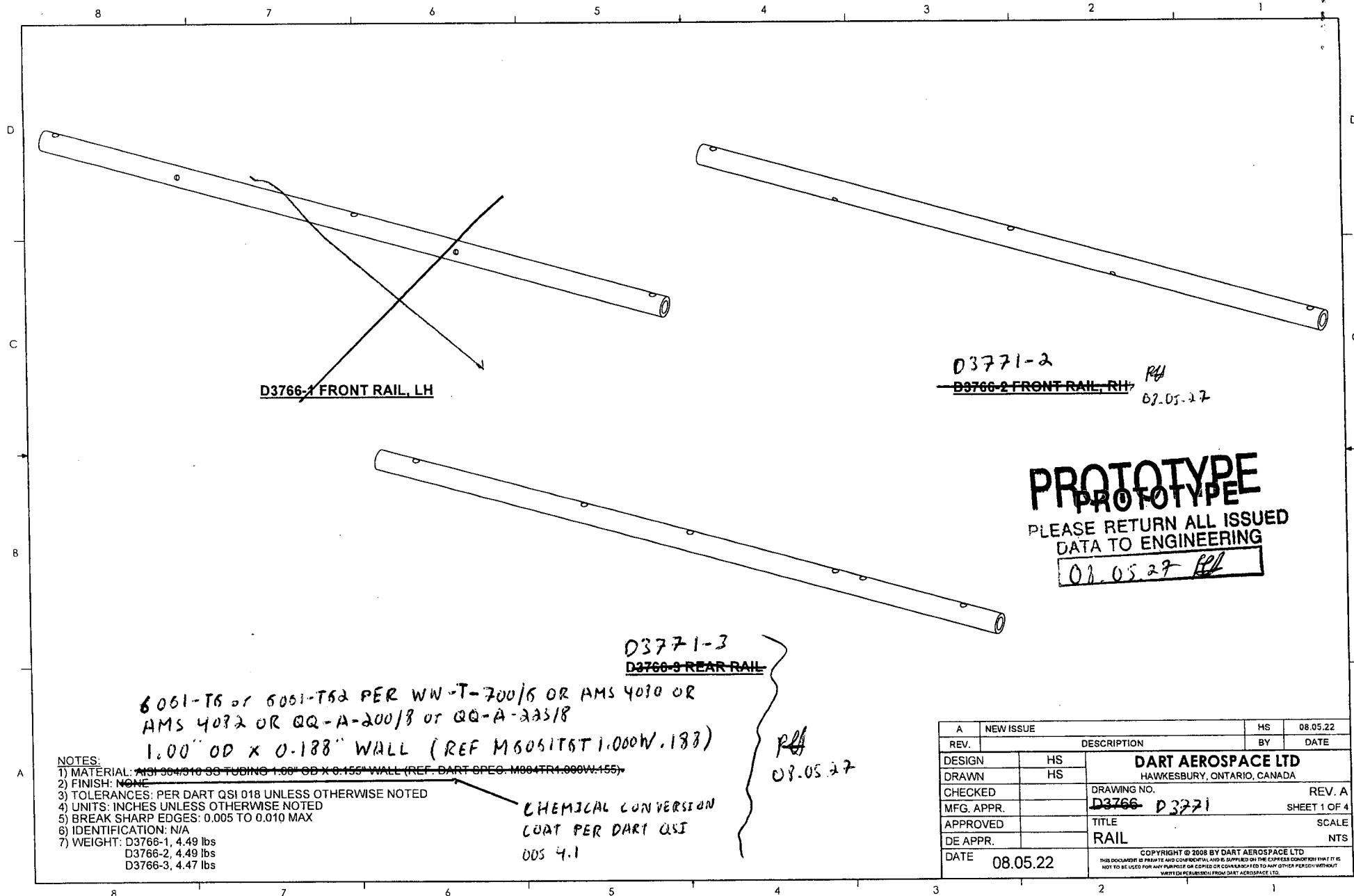
Product Name: Aft facing seat

Requested By: PH/HS

Design Manager Approval: 

Quantity	Part Number	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
1	D3771-2	Front Rail, <del>LA</del> RH	08.05.22	Y	08.05.29	Aluminum Tubing	
1	D3771-3	Rear Rail	08.05.22	Y	08.05.29	Aluminum Tubing	

38874



D3766-1 FRONT RAIL, LH

D3771-2

D3766-2 FRONT RAIL, RH

RA

08.05.27

**PROTOTYPE**  
**PROTOTYPE**  
 PLEASE RETURN ALL ISSUED  
 DATA TO ENGINEERING  
 08.05.27 RA

D3771-3

D3766-3 REAR RAIL

6061-T6 or 6061-T62 PER WW-T-700/6 OR AMS 4030 OR  
 AMS 4032 OR QQ-A-200/8 or QQ-A-233/8  
 1.00" OD X 0.188" WALL (REF M6061T6T1.000W.188)

RA  
 08.05.27

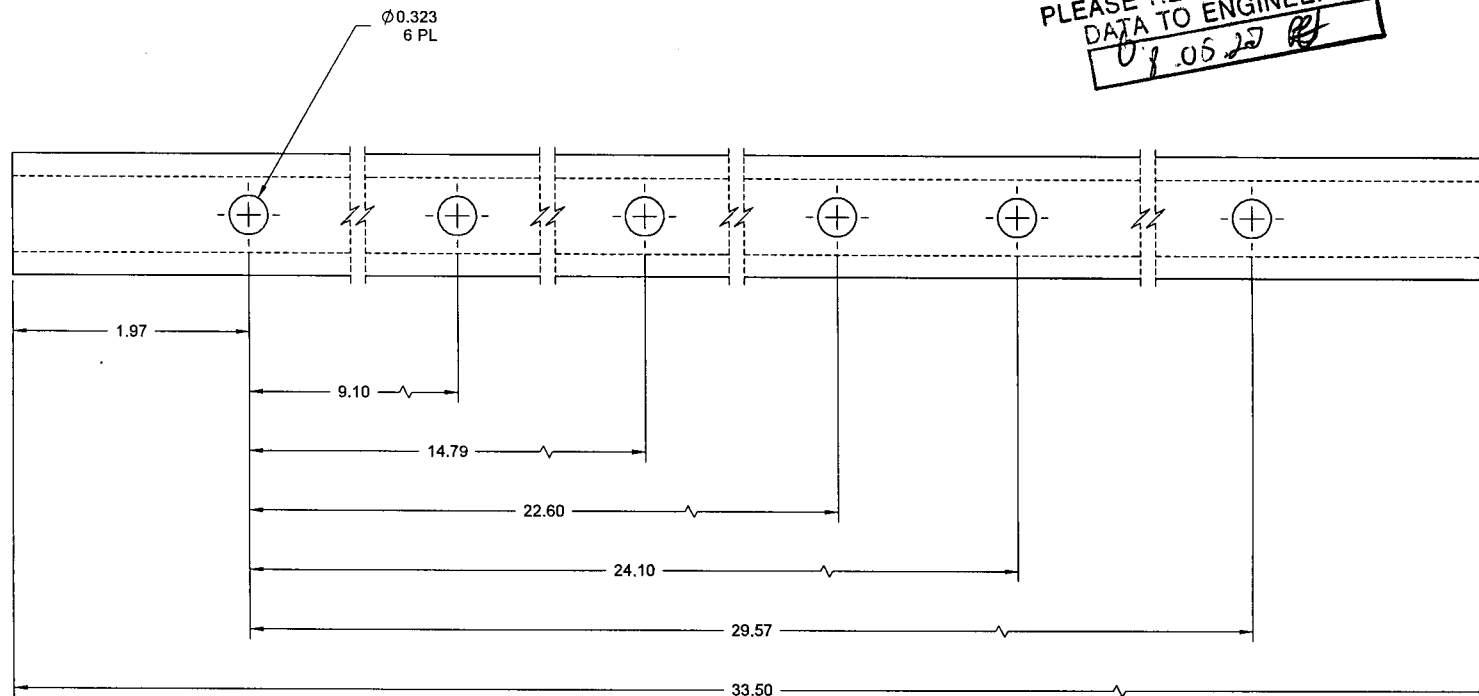
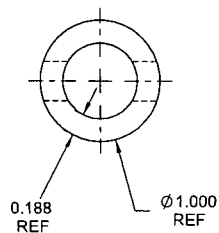
CHEMICAL CONVERSION  
 COAT PER DART QSI  
 005 4.1

**NOTES:**

- 1) MATERIAL: ~~MSI 304/316 SS TUBING 1.00" OD X 0.155" WALL (REF. DART SPEC. M004TR1.000W.155)~~
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3766-1, 4.49 lbs  
 D3766-2, 4.49 lbs  
 D3766-3, 4.47 lbs

A NEW ISSUE		HS	08.05.22
REV.	DESCRIPTION		BY DATE
DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<del>D3766</del> D3771	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		RAIL	NTS
DATE	08.05.22	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD          THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS          NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT          WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

**PROTOTYPE**  
 PLEASE RETURN ALL ISSUED  
 DATA TO ENGINEERING  
 08.05.22



**D3771-3**  
**D3766-3 REAR RAIL**

DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D3766-3 D3771</b>	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		<b>RAIL</b>	NTS
DATE	08.05.22	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD          THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS          NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT          WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

# Receiving Report

Batch No: M104779

Dart P/O: 3789

Date: 07/06/19

Supplier: Camp

Release Note Attached: Yes ☒ No ☒  
Waybill Attached: Yes ☒ No ☒  
Shipment Complete: Yes ☒ No ☒  
QC6 Inspection: CR 07/06/19 N/A ☒  
Work Order: \_\_\_\_\_

Packing Slip: Yes ☒ No ☒  
Invoice: Yes ☒ No ☒  
Receipt: Cash ☒ Cr ☒

Discrepancies	Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12 \_\_\_\_\_

Location \_\_\_\_\_

Production/Admin: \_\_\_\_\_

Date: 07/06/20

Received/Costing: RIP 4902

Initial: CR

H:\FORMS\Purchasing\approved purchase\REPORT Rev D

50 377-4248  
50 377-5696

MONTREAL : 514 336-4248  
FAX : 514 336-4246

DISTRIBUTEUR D'ACIER ET METAUX SPECIALISES  
STEEL AND SPECIALTY METALS DISTRIBUTOR

ONTARIO : 1 800 667-4248  
FAX : 1 866 456-4242

On a du Savoir "FER"

A / SHIP TO:

IVED JUL 03 2007

OSPACE LTD  
RDEEN STREET  
RY,

FACTURE  
INVOICE N° 176053

DATE 19/06/07

BON DE LIVRAISON  
PACKING SLIP N° 121607

DATE DE LIVRAISON  
DELIVERY DATE 19/06/07

TERMES / TERMS	TERR.	REMARQUES / REMARKS	PAGE N°
NET 30 JOURS	2R		001

DESCRIPTION	POIDS WEIGHT	PRIX PRICE	PAR PER *	MONTANT AMOUNT
2 X .188	192	5.350		1027.20
CHARGE	1	0.000	UN	0.00

POIDS TOTAL 193.00  
TOTAL WEIGHT

Formplus N° 8619

ALL REMAIN THE PROPERTY OF "ACIER CAMP" INC. UNTIL PAYMENT IS MADE IN FULL, COMPLETE AND CASHED. BUYER'S EXPENSE. \* ALL MATERIALS BEAR THE SAME WARRANTY AS GIVEN BY THE MANUFACTURER. \* SPECIFY THE FOLLOWING CONDITIONS: NET 30 DAYS FROM BILLING DATE AND THE BUYER ACCEPTS TO PAY 1 MONTH OR 24% PER ANNUM ON ALL PAST DUE ACCOUNTS OVER 30 DAYS. \* ANY DEFAULT IN RESPECT WITH IN BY ACCELERATION AND PERMITS TO THE SELLER, AT HIS CHOICE TO CLAIM FOR THE BALANCE DUE OR THE \* ANY CLAIM MUST BE MADE WITHIN FIVE DAYS WITH THIS DOCUMENT ENCLOSED. \* ANY MERCHANDISE MODIFIED CANNOT BE RETURNED. \* ALL GOODS RETURNED MUST BE WITH OUR AUTHORIZATION AND ARE SE.

ONNE CONDITION MERCHANDISE RECEIVED IN GOOD CONDITION

A/Y M/M J/D

ENT / CUSTOMER'S SIGNATURE

DATE

SOUS-TOTAL 1027.20  
SUB TOTAL

T.P.S. 61.63  
G.S.T.

T.V.Q. 0.00  
Q.S.T.

TOTAL 1088.83

**CERTIFIED TEST REPORT**

CUSTOMER PO NUMBER: <b>60-27683</b>		CUSTOMER PART NUMBER: <b>ESRT733 1.188X24</b>		PRODUCT DESCRIPTION: <b>1.00 OD X .188 WALL</b>	
KAISER ORDER NUMBER: <b>993166</b>	LINE ITEM: <b>001</b>	SHIP DATE: <b>02/07/2007</b>	KAISER LOT NUMBER: <b>50924 036</b>	ALLOY: <b>6061</b>	TEMPER: <b>T6511</b>
WEIGHT SHIPPED: <b>1003.000 LB</b>	QUANTITY: <b>74.000 PCS</b>	B/L NUMBER: <b>936965</b>	DIAM/DAFT/HKNS:	WIDTH:	LENGTH: <b>24.000 FT</b>
SHIP TO: <b>MARMON-KEYSTONE CORP 10700 MARMON DR BOLINGBROOK, IL 60440-3060 USA</b>			SOLD TO: <b>MARMON-KEYSTONE CORP 10700 MARMON DR BOLINGBROOK, IL 60440-3060 USA</b>		

**Actual Physical Properties**

REFERENCE	DASH#	SAMPLE#	UTS (KSI)	YTS (KSI)	%Elong in 2	HARDNESS	CONDUCT.	REMD
XTR058141	0001	001	45.5	41.5	16.7	NA	N/A	N/A
XTR058141	0001	002	44.9	40.4	13.6	NA	N/A	N/A
XTR058141	0001	003	42.3	38.7	13.7	NA	N/A	N/A

**Chemical Composition (wt%), Aluminum Remainder**

LIMITS	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Bi	Sr	Ca	Tot
Maximum	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	NA	NA	NA	0.05	0.15
Minimum	0.40		0.15		0.8	0.04			NA	NA	NA		

**APPLICABLE REQUIREMENTS:**

ASTM-B241-02-STENCILED    ASTM-B221-02    ASME-SB241 1998 SECT II    AMS-QC-A-100-R TYPE 1  
ASTM-B345-02    UNS#96061    (T6511 also conforms to T6-not applicable to other temper)

**Miscellaneous Notes**

MANUFACTURED IN USA    MELTED IN USA

**CERTIFICATION**

Kaiser Aluminum & Chemical Corp. ("Kaiser") hereby certifies that metal shipped under this order has been inspected and tested and found in conformance with the applicable specification forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms & conditions of sale. Test reports are on file, subject to examination.

Frank E. Watson, Quality Assurance Manager

*Frank E. Watson*

Plant Serial: 10156820

Kaiser Order Number: 993166

Line Item: 001

AT 1.188 733